

Identification

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Responsible partner: S4080 (Pilatus Aircraft Ltd)
Originator: S4080 (Pilatus Aircraft Ltd)
Quality assurance: First verification: Table Top
Reason for update: 18496 - Update for maintenance schedule changes
Applicable to: Model: ALL

WINDOWS - INSPECTION/CHECK**References**

Code	Name	IssNo
12-A-04-00-00-00A-000A-A	PC-12, PC-12/45, PC-12/47 STRUCTURAL, COMPONENT AND MISCELLANEOUS LIMITATIONS - AMM DOCUMENT NO. 2049 - AIRWORTHINESS LIMITATIONS	
12-A-12-20-02-00A-902A-A	AIRCRAFT WINDOWS CLEANING - SERVICING	
12-A-30-40-00-00A-903A-A	WINDSHIELD DE-ICE SYSTEM (WINDSHIELDS WITH TWO HEATING ELEMENTS) - ADJUSTMENT/TEST	
12-A-30-40-00-00A-903B-A	WINDSHIELD DE-ICE SYSTEM (WINDSHIELDS WITH THREE HEATING ELEMENTS) - ADJUSTMENT/TEST	
12-A-56-00-00-00A-904A-A	WINDOWS - REPAIR	
12-A-56-11-01-00A-920A-A	WINDSHIELD - REMOVAL/INSTALLATION	
12-A-56-11-02-00A-920A-A	INNER SIDE WINDOWS - REMOVAL/INSTALLATION	
12-A-56-20-01-00A-920A-A	CABIN WINDOWS - REMOVAL/INSTALLATION	

Preliminary Requirements**Required Conditions**

-- none --

Support Equipment

-- none --

Supplies

-- none --

Spares

-- none --

Safety Conditions

-- none --

Main Function



☐ 1 General

This data module is referenced from the AMM Airworthiness Limitations data module [12-A-04-00-00-00A-000A-A](#).

This data module gives the inspection procedure and damage limits for:

- The windshields in the flight compartment
- The outer side and DV windows in the flight compartment
- The inner side windows in the flight compartment
- The windows in the passenger compartment.

☐ 2 Examine The Windshields In The Flight Compartment

☐ 2.1 Preparation

Clean the windows, refer to AMM [12-A-12-20-02-00A-902A-A](#).

☐ 2.2 Procedure

☐ 2.2.1 Examine the windshields for delamination.

Delamination is permitted if:

- It extends less than 100 mm (4 in) from the corner edges and less than 75 mm (3 in) from the remaining outer-edges of the windshield fiberglass outer-strap to the center of the windshield
- It is in an area nearer to the center of the windshield and the pilots view is satisfactory.

☐ 2.2.2 Examine the windshields for bubbles.

Bubbles are permitted if:

- The pilots view is satisfactory
- The windshield de-ice system operates correctly, refer to AMM [12-A-30-40-00-00A-903A-A](#) or [12-A-30-40-00-00A-903B-A](#).

☐ 2.2.3 Examine the windshields for changes of color.

Note

White cloudy areas around the area of the windshield fiberglass outer-strap are typical when there is moisture in the delaminated area. Black or brown discoloration at the electrical bus bars, lead wires or heating elements show that there is an error in the windscreen electrical circuits.

Changes of color are permitted if:

- The pilots view is satisfactory
- The windshield de-ice system operates correctly, refer to AMM 12-A-30-40-00-00A-903A-A or 12-A-30-40-00-00A-903B-A.

- ☐ 2.2.4 Examine the windshields for cracks. No cracks are permitted in the inner lamination. If the outer lamination is cracked, only unpressurized flight is permitted up to the next scheduled inspection, provided the crack does not cause visual problems.
- ☐ 2.2.5 Examine the windshields for scratches. Use ASTM F 428 "Standard Test Method for Intensity of Scratches on Aerospace Glass Enclosures" and compare the results with ASTM F 428 "Glass Scratch Visual Comparison Standard".
 - ☐ 2.2.5.1 Scratches are permitted if they are less than or the same as ASTM F 428 -6 standard.

Note

You do not have to measure the length of the scratches.

- ☐ 2.2.5.2 If the scratches are more than ASTM F 428 -6 standard you must replace the related windshield(s), refer to AMM 12-A-56-11-01-00A-920A-A.
- ☐ 2.2.5.3 Examine the windshields for arcing. Arcing is not permitted.

- ☐ 2.2.6 Examine the bonding of the windshield fiberglass outer straps. If there are signs of de-bonding and the strap can be lifted with finger pressure, do the repair procedure, refer to AMM 12-A-56-00-00-00A-904A-A.
- ☐ 2.2.7 Do the adjustment/test of the windshield de-ice system, refer to AMM 12-A-30-40-00-00A-903A-A or 12-A-30-40-00-00A-903B-A.

☐ 3 Examine The Outer Side And DV Windows In The Flight Compartment

- ☐ 3.1 Examine the windows for cracks. Cracks are not permitted. If you find cracks, replace the window, refer to AMM 12-A-56-11-01-00A-920A-A.
- ☐ 3.2 Examine the window for crazing. If you find crazing, repair the window if required, refer to AMM 12-A-56-00-00-00A-904A-A.
- ☐ 3.3 Examine the windows for delamination. Delamination is permitted if:
 - The delamination extends less than 75 mm (3 in) from the edge of the seal to the center of the window
 - The pilots view is satisfactory.

- ☐ 3.4 Examine the windows for bubbles. Bubbles are permitted if the pilots view is satisfactory.
- ☐ 3.5 Examine the windows for change of color. Change of color is permitted if the pilots view is satisfactory.
- ☐ 3.6 Examine the windows for scratches. Scratches are permitted if:
 - The depth of the scratch is less than 0,1 mm (0.004 in)
 - The length of the scratch is less than 50 mm (2 in)
 - The pilots view is satisfactory.

If necessary remove the scratches from the windows, refer to AMM [12-A-56-00-00-00A-904A-A](#).

- ☐ 3.7 Examine the edges of the windows for chips (as far as possible with the windows installed). Chips are permitted if:
 - The chips are less than 0,4 mm (0.016 in) in depth
 - The chips are less than 5 mm (0.2 in) diameter
 - The pilots view is satisfactory.

- ☐ 3.8 **At 1200 FH or 12 Months, whichever comes first, only** - Make sure that you can open and close the DV window with one hand.

☐ 4 **Examine The Inner Side Windows In The Flight Compartment**

- ☐ 4.1 Examine the windows for cracks. Cracks are permitted if:
 - There is no visual distortion
 - Two or more cracks do not join together and cause a part of the glass to be loose.

- ☐ 4.2 If the cracks are in limits:
 - ☐ 4.2.1 Remove the inner side window, refer to AMM [12-A-56-11-02-00A-920A-A](#).
 - ☐ 4.2.2 Stop-drill all of the cracks.
 - ☐ 4.2.3 Install the inner side window, refer to AMM [12-A-56-11-02-00A-920A-A](#).

- ☐ 4.3 Examine the windows for scratches. Scratches are permitted if:
 - The amount of visual distortion is small
 - The depth of the scratches is less than 0,1 mm (0.004 in).

- ☐ 4.4 If necessary, remove scratches from the windows, refer to AMM [12-A-56-00-00-00A-904A-A](#).

- ☐ 4.5 Examine the edges of the windows for chips (as far as possible with the windows installed). Chips are permitted if:
 - The amount of visual distortion is small
 - The chips are less than 0,4 mm (0.016 in) in depth
 - The chips are less than 5 mm (0.2 in) diameter.

☐ 5 **Examine The Cabin Windows**

- ☐ 5.1 Examine the windows for cracks. Cracks are not permitted. If there are cracks replace the related window, refer to AMM [12-A-56-20-01-00A-920A-A](#).
- ☐ 5.2 Examine the window for crazing. Crazing is permitted unless found aesthetically unacceptable by the operator. Repair the window if required, refer to AMM [12-A-56-00-00-00A-904A-A](#).
- ☐ 5.3 Examine the windows for delamination. Delamination is permitted if the delamination extends less than 75 mm (3 in) from the edge of the seal to the center of the window.
- ☐ 5.4 Examine the windows for bubbles. Bubbles are permitted if the view is satisfactory.
- ☐ 5.5 Examine the windows for change of color. Change of color is permitted if the view is satisfactory.
- ☐ 5.6 Examine the windows for scratches. Scratches are permitted if:
- The depth of the scratch is less than 0,1 mm (0.004 in)
 - The length of the scratch is less than 50 mm (2 in).

If necessary remove the scratches from the windows, refer to AMM [12-A-56-00-00-00A-904A-A](#).

- ☐ 5.7 Examine the edges of the windows for chips (as far as possible with the windows installed). Chips are permitted if:
- The chips are less than 0,4 mm (0.016 in) in depth
 - The chips are less than 5 mm (0.2 in) diameter.

Requirements after job completion

-- none --